

**ABSTRACT**

5      Procedure for the production of sleeves for mini-deadheads, in which a fluoride-free mixture, consisting of microspheres of aluminium silicate, an oxidizable metal, such as powdered aluminium, an oxidizable agent, magnesium as initiator element of the exothermic reaction, are introduced by blowing in a mould fitted with two cores to produce a sleeve provided with two openings, one of which is closed with a plug before being used.